

Work Order ID 67396-1

Friday, March 18, 2011 6:39:28 AM

Page 1

Item ID: D2230-1

Revision ID:

Item Name: Lug

Start Date: 3/18/2011

Start Qty: 100.00

Required Date: 4/6/2011

Req'd Qty: 100.00

Reference:

Approvals: Process Plan:

QC:

Date: 11/03/18

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 extrusion to 0.82"

Batch:

cut extrusion @ meter

0.00

0.00

CL 11/03/18

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA927

DWG REV:

FOLIO REV:

(Check for crack while loading into the machine.)

2- deburr rough edges

issue P/O to meter

P/O: 13677

Machine as per P.O. &

0.00

0.00

CL 11/03/18

100

Work Order ID 67396

Friday, March 18, 2011 6:39:28 AM



Page 2

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/18/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC2-Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Need + inspect for transfered damage + attached cap to W/O

Ref 4/6/11 (77)

130

QC3-Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

See 4/04/11

counted (x77)

140

Chemical Conversion Coat per QSI005 4 I

0.00



HandFinish

Memo

0.00

Hand Finishing

77 p 24 4/04/11

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Required Date: 4/6/2011 Req'd Qty: 100.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

77 BL 11-4-4

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M 115951

Memo

START TIME: 12:00
OVEN TEMPERATURE: 320°
FINISH TIME: 12:30

0.00

0.00

77 BL 11-4-4

170



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

77 BL 11-4-4

Work Order ID 67396

Friday, March 18, 2011 6:39:28 AM



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Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/18/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: 476

0.00



Packaging

Memo

0.00

Packaging

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/4/5 (22)

11/4/5 DJ

ME
11-04-05

Picklist Print

Friday, March 18, 2011 6:39:24 AM

Page 1

Work Order ID: 67396



Parent Item: D2230-1

Parent Item Name: Lug

Start Date: 3/18/2011

Start Qty: 100.00

Required Date: 4/6/2011

Required Qty: 100.00

Comments: IPP D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423



Lug Extrusion

Manufactured No

110

f

477.0414

0.0683

7.189474



CL11/03/18

Location

MAT006

43722

45800

63005

Loc Qty

477.0414265

180

16.1914265

280.85

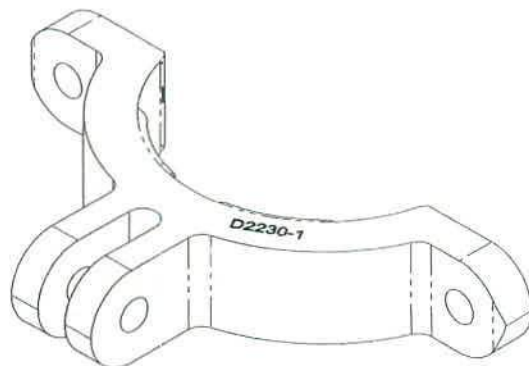
Loc Code

7.19

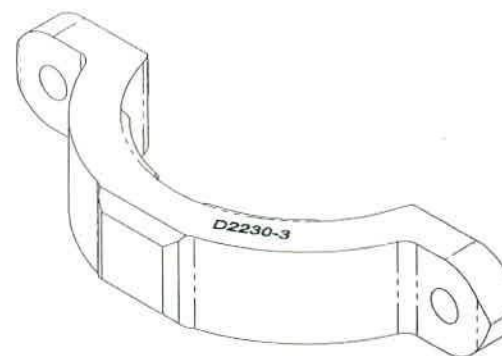
D2230-1P

X100

4/1/11 (77)



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

041003118
W10.67396

RELEASED
01/03/03



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ±0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

REV	DESCRIPTION	BY	DATE																										
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16																										
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13																										
E	RE-DESIGN	BW	95.01.04																										
D	RE-DESIGN	BW	95.01.04																										
C	RE-DESIGN	BW	94.03.30																										
<table border="1"> <tr> <td>DESIGN</td><td>BV</td><td colspan="2" rowspan="2"> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA </td></tr> <tr> <td>DRAWN</td><td>AJS</td></tr> <tr> <td>CHECKED</td><td></td><td>DRAWING NO.</td><td>REV. G</td></tr> <tr> <td>MFG APPR.</td><td></td><td>D2230</td><td>SHEET 1 OF 3</td></tr> <tr> <td>APPROVED</td><td></td><td>TITLE</td><td>SCALE</td></tr> <tr> <td>DE APPR.</td><td></td><td>MOUNTING LUG</td><td>NTS</td></tr> <tr> <td>DATE</td><td>09.01.16</td><td colspan="2"> <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> </td></tr> </table>				DESIGN	BV	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWN	AJS	CHECKED		DRAWING NO.	REV. G	MFG APPR.		D2230	SHEET 1 OF 3	APPROVED		TITLE	SCALE	DE APPR.		MOUNTING LUG	NTS	DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL

0.273
REF

0.306

0.345

R0.125
REF

0.250

0.735
REF

SYM ABOUT

FILLET EDGE
PER SECTION
A-A

MACHINE TO
SIZE

D2230-1

6

MACHINE TO
SIZE

0.375

3.700

3.443

$\phi 0.257^{+0.005}_{-0.000}$

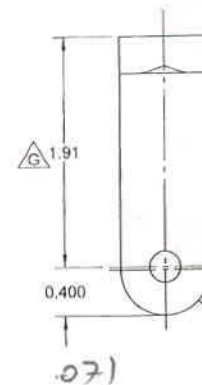
0.750

R0.38
REF

SYM ABOUT

D2230-1 MOUNTING LUG

W10.67396



0.025
REF

R0.38
REF

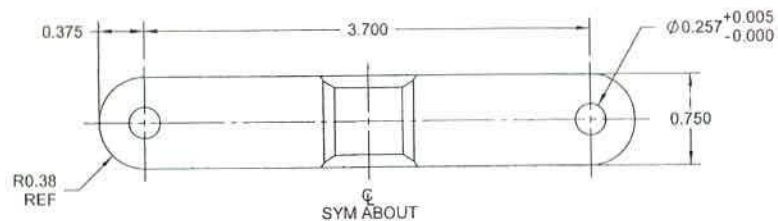
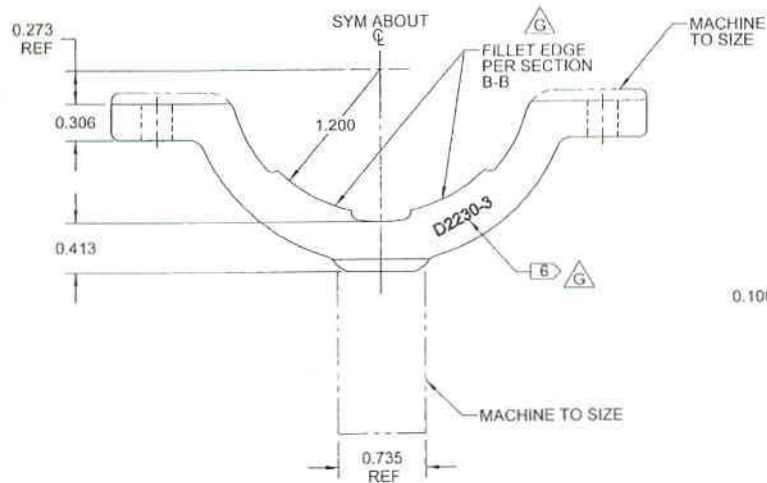
RELEASED
09/06/95

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

W10:61396

RELEASED
07/06/23

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17860
Date: Apr 01, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13677	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	77	
Received by <u>Henry B...</u>		Thank you for your order!		

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
77	D2230-1	Mounting Lug	13677

MATERIAL: supplied by DART D2423 B63005

Sulsky

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, April 1, 2011